

Date: Monday, 28/04/2008 8:13:39 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: AFT CROSSTUBE		
Job Number	: 38818		Part Number	: D2890		
Estimate Number	: 10377		Drawing Number	: D2890 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 28/04/2008 S.O. No. :		Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : PURCHASED PARTS		Due Date	: 30/05/2008 Qty: 1 Um: Each		
Previous Run	: 38668					
Written By	:					
Checked & Approved By	: JLD 08.4.28					
Comment	: Est. D 05.03.21 Removed Bending procedures KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D6008180	Crosstube Extrusion		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	Pick:			
Qty Part # Description	Batch			
1 D6008-180 Crosstube extrusion	<u>B338341</u>	<u>LZ 8-6-18</u>		
2.0 BENDING BENDING MACHINE - SKIDTUBES				
Comment: BENDING MACHINE				
1-Bend D2890 as per Dwg D2890 and Folio FT002				
3.0 QC6	DIMENSIONAL CHECK			
Comment: DIMENSIONAL CHECK				
3.0 QC6	DIMENSIONAL CHECK			
Comment: LANDING GEAR RESOURCE 1				
1-Deburr and Polish				
5.0 HAND FINISHING1	HAND FINISHING RESOURCE #1			
Comment: HAND FINISHING RESOURCE #1				
Chemical Conversion Coat as per QSI 005 4.1				
Weld on work only				
B 39794 out of tolerance				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 38818		Part Number: D2890
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
7.0	PACKAGING 1	PACKAGING RESOURCE #1
8.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location:		
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		 MF 08-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

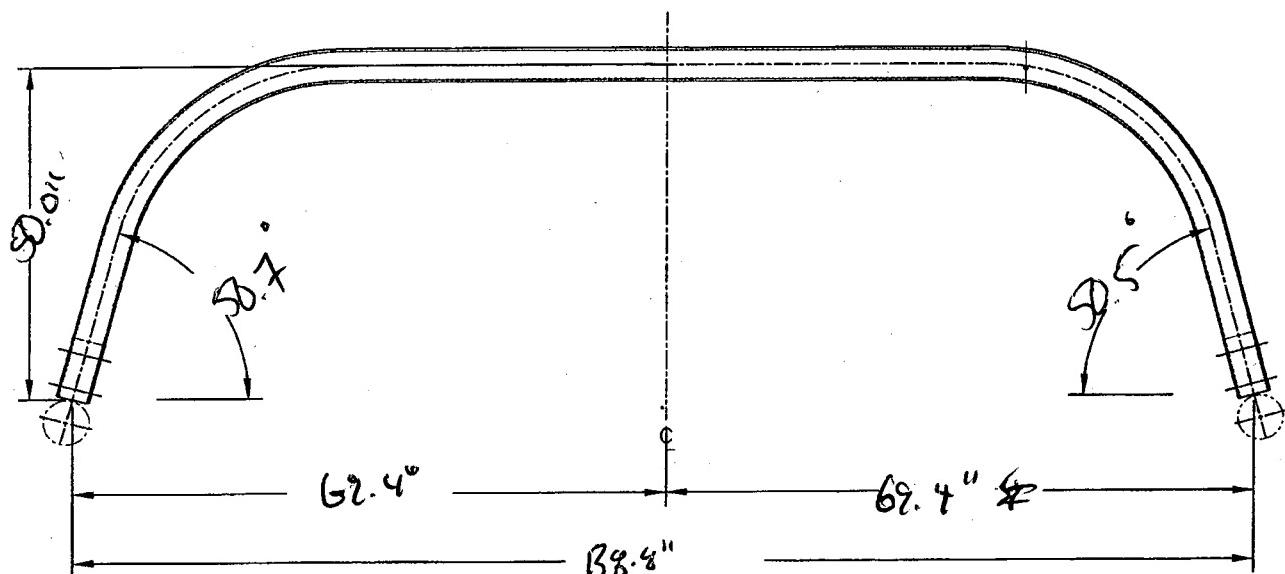
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38818
Description: Crosstube Aft	Part Number:	D2890
Inspection Dwg: D2890	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
used on w/o # 38794

QC15 Inspection	
Date	08/06/18

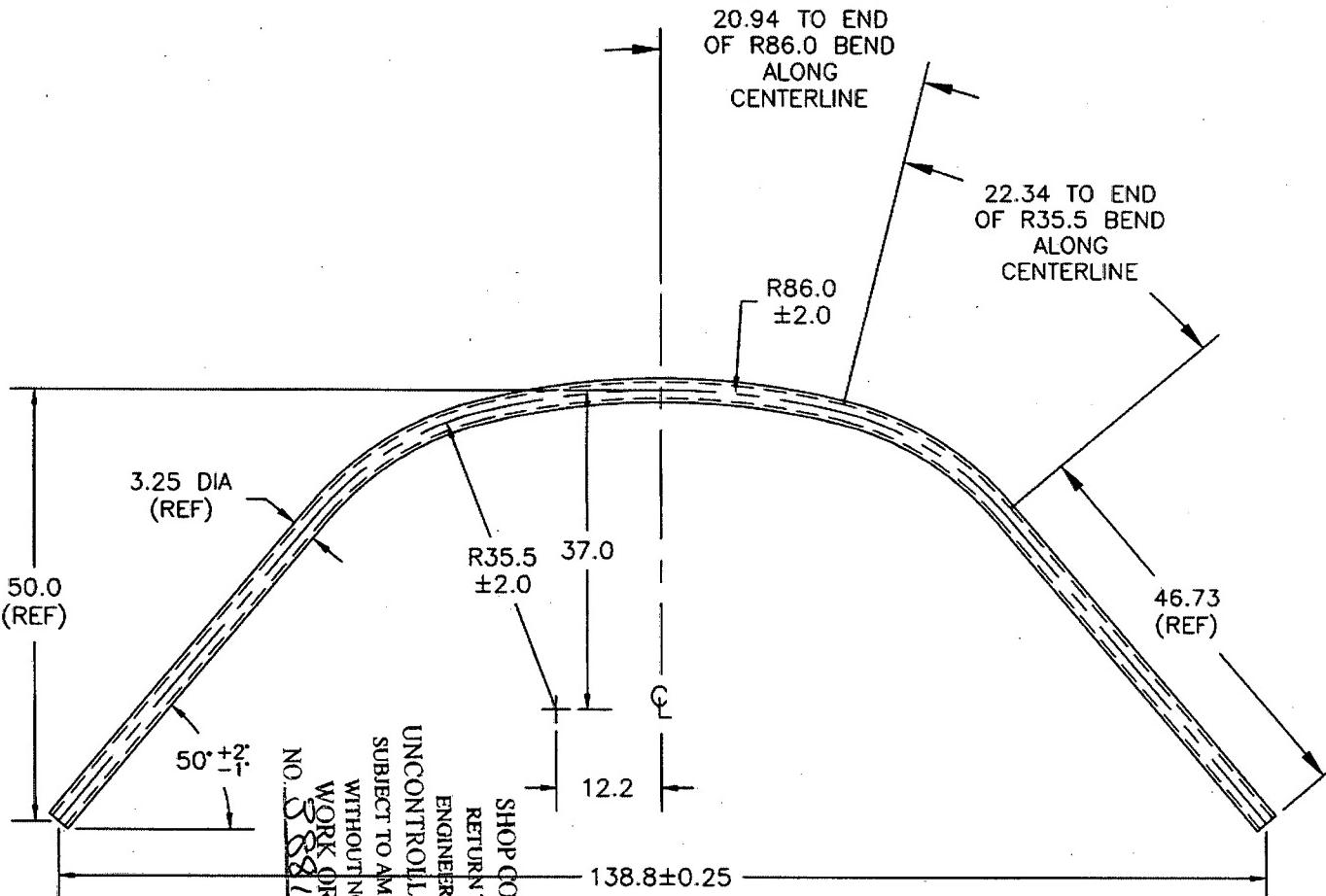
Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	[Signature]

DART



RELEASED
R 02.10.28

DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKSBURY, ONTARIO, CANADA	
CHECKED	APPROVED	REV. B	
		DRAWING NO.	
		D2890	SHEET 1 OF 1
DATE	TITLE	SCALE	
02.10.18	AFT CROSSTUBE	1:20	
A	99.05.21	NEW ISSUE	
B	02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES	



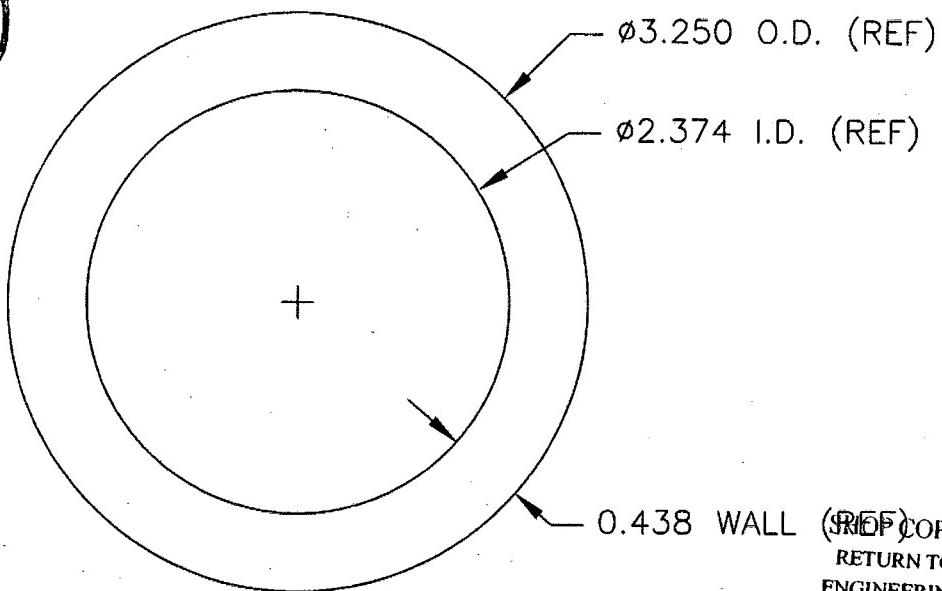


OF COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D6008
DATE		REV. A SHEET 1 OF 1
00.11.17		TITLE CROSSTUBE MATERIAL
A	00.11.17	SCALE 1:1 NEW ISSUE

SPECIFICATION CONTROL DRAWING

RELEASED
00.11.24 #



NOTES

1) D6008-XXX CROSSTUBE

LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 180" LONG TUBE: D6008-180

(REF)
COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38818

- 2) MATERIAL: 3.250 OD x 0.438 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.008 MEAN (± 0.016 INCLUDING OVALITY)
WALL: ± 0.020 MEAN (± 0.044 INCLUDING ECCENTRICITY)
LENGTH: XXX +0.125/-0.000
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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